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D2322

Job Sheet 199394



Part No: D2322

Job Qty: 30 pcs

DAS
21
9-89

Part Name: Step Spacer



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/21/19

Job Tracking No:

Due Date: 8/23/19

Created By: Jason Leroux

Type: SOLD

Description:

Note: DWG REV C IPP Rev:A New Issue 05-11-07 JLM IPP Rev;B Now on Waterjet 06-07-03 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	30 pcs		8/23/19	0.17	1.66	Waterjet - Flow		SRB
120	QC 8	30 pcs		8/23/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		smf
							QC 8 - 8		19/8/20
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
130	Small Fab - Brake NC - B4B	30 pcs		8/23/19	0.25	0.95	Small Fab - Brake - 1 - B4B		
							Small Fab - Brake - 2 - B4B		
							Small Fab - Brake - 3 -		AUG 22 2019

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				B4B	
140 QC 5	30 pcs	8/23/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
150 Handfinish - 1-1 Chemical-B4B	30 pcs	8/23/19	0.00 1.20	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
160 QC 7	30 pcs	8/23/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	

Smf
19/8/22

BEB/9-08-22.

					QC 7 - 51	
					QC 7 - 58	Smb
					QC 7 - 59	
					QC 7 - 60	19/8/22
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
170	Packaging 3-1 - Stock - B4B	30 pcs	8/23/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	Smb
					Packaging 3 - 8 - B4B	19/8/22
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
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					Packaging 3 - 19 - B4B	
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					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
180	QC 21 - SA	30 pcs	8/23/19	0.00 0.00	QC 21 - SA - 21	DAB
					QC 21 - SA - 70	21
					QC 21 - SA - 53	9-89

Part Op 100 - 1-Cut as per Dwg D2322

Descriptions: 120 - (QC8- Inspect parts - second check)

130 - Form as per Dwg D2322

140 - (QC5- Inspect part completeness to step on W/O)

150 - (Chemical Conversion Coat per QSI005 4.1)

160 - (QC7-Inspect Chemical Conversion Coat)

170 - (Identify as per dwg & Stock Location:) LOCATION : GA

180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.040	2024-T3 .040 Sheet	6.0900 sf (.203 ea)	100-Waterjet - Flow - 1	5191572

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.040	6	134	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Step Spacer	0.250Inches ± 0.005	0.255 0.245		
2	Step Spacer	4.178Inches ± 0.005	4.183 4.173		
3	Step Spacer	4.428Inches ± 0.010	4.438 4.418		
4	Step Spacer	0.250Inches ± 0.005	0.255 0.245		
5	Step Spacer	6.520Inches ± 0.010	6.530 6.510		
6	Step Spacer	0.128Inches + 0.005 - 0.000	0.133 0.128	Diameter	
7	Step Spacer	0.125Inches ± 0.010	0.135 0.115	Radius	

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Container No: S207802



Part: D2322

Job No: 199394

Serial No/Batch: S207802

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 08/21/19